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IS 11059 (1984): Cylindrical Tubes for Open-end Spinning
[TXD 14: Machinery for Fabric Manufacture]



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Indian Standard

SPECIFICATION FOR CYLINDRICAL
TUBES FOR OPEN-END SPINNING

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NEW DELHI 110002

Indian Standard

SPECIFICATION FOR CYLINDRICAL TUBES FOR OPEN-END SPINNING

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Indian Standard

SPECIFICATION FOR CYLINDRICAL TUBES FOR OPEN-END SPINNING

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 10 September 1984, after the draft finalized by the Textile Mill Accessories (Other Than Jute) Sectional Committee had been approved by the Textile Division Council.

0.2 The dimensions of tubes as specified in the standard are based on ISO 3914/2-1981 ' Cylindrical tubes-Part 2: Tubes for open-end spinning machines ', issued by the International Organization for Standardization (ISO).

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes the requirements for cylindrical tubes for open-end spinning machines (for example, for rotor spinning).

2. MANUFACTURE

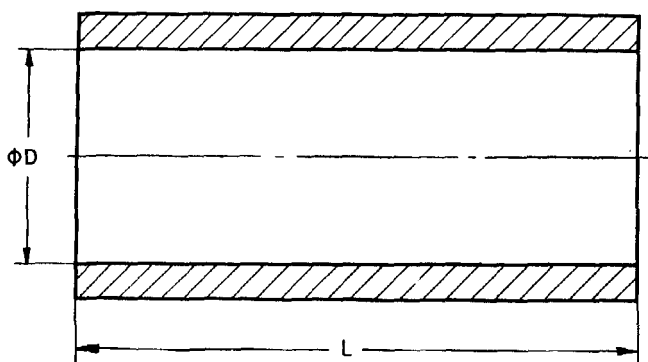
2.1 Material — The tubes shall be made of paper or polypropylene, or any other material as agreed to between the buyer and the seller.

2.2 Workmanship and Finish — The tubes shall have grooved or embossed finish in case of paper and velveteed or flock finish in case of polypropylene. The tube shall have suitable provision for transfer tail. The surface of tube shall be free from sharp edges or burrs.

3. REQUIREMENTS

3.1 Dimensions — The inner diameters and lengths of tubes shall be as given in Fig. 1. The dimensions which are not specified are subject to agreement between the buyer and the seller.

*Rules for rounding off numerical values (*revised*).

INNER DIAMETER (D)

mm

50 ± 0.2
 54 ± 0.2 }
 56 ± 0.2 }
 63 ± 0.2 }
 80 ± 0.25

LENGTH (L)

mm

98 ± 0.5
 115 ± 0.5 , or
 145 ± 0.5 , or
 170 ± 0.5
 230 ± 1

FIG. 1 A TYPICAL CYLINDRICAL TUBE

3.1.1 To check the inner diameter of tube, a GO/NOT-GO type gauge shall be used. To control the length of tube within the tolerances specified, a suitable slide gauge shall be used.

3.2 Concentricity — The tubes shall be concentric. However, eccentricity of 0.2 mm at top and bottom of tube shall be permissible.

3.3 Mass — The average mass of tube shall be as agreed to between the buyer and the seller subject to a tolerance of ± 8 percent for paper and ± 2 percent for polypropylene. The mass of tubes is to be determined on a random sample of 100 tubes.

4. MARKING

4.1 Each tube shall be marked with manufacturer's initials or trade-mark, if any.

4.1.1 The tubes may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors may be obtained from the Indian Standards Institution.

4.2 Each case/carton of tubes shall also bear the following information:

- a) Manufacturer's name, initials or trade-mark, if any;
- b) Material of tubes;
- c) Number of tubes;
- d) Gross and net mass; and
- e) Lot/batch number.

5. PACKING

5.1 A suitable number of tubes shall be packed in cases/cartons strong enough to withstand normal hazards of storage and transport.

6. SAMPLING

6.1 Unless otherwise agreed to between the buyer and the seller the sampling inspection shall be carried out in accordance with IS : 2500 (Part 1)-1973*. For this purpose, an AQL of 4 percent and inspection level IV shall be followed.

*Sampling inspection tables: Part 1 Inspection by attributes and by count of defects (*first revision*).

INDIAN STANDARDS

ON

TEXTILE MILL ACCESSORIES (OTHER THAN JUTE)

IS:

- 1794-1971 Shuttles for plain calico looms (*first revision*)
- 1896-1970 Picking sticks for overpick cotton looms (*first revision*)
- 2058-1973 Shuttles for pirn-changing automatic cotton looms (*first revision*)
- 3265-1971 Weft pirns (taper fit) for use in shuttles for plain calico looms (*first revision*)
- 3496-1966 Dobby lags and pegs
- 3625 Warp tubes for ring spinning and doubling spindles:
 - (Part 1)-1983 Specific requirements (*second revision*)
 - (Part 2)-1984 Recommended dimensions for tubes, taper 1 : 38 (*second revision*)
 - (Part 3)-1984 Recommended dimensions for tubes, taper 1 : 64 (*second revision*)
- 3834-1966 Lease rods for cotton looms
- 4187-1966 Skewers for use on cotton speed frames
- 4416-1967 Dobby barrels
- 4417-1971 Weft pirns for shuttles for pirn-changing automatic cotton, woollen and worsted looms (*first revision*)
- 4775-1976 Picking sticks for automatic underpick looms (*first revision*)
- 4888 Cones for yarn winding:
 - (Part I)-1982 Half angle of the cone 3° 30' (*second revision*)
 - (Part II)-1982 Half angle of the cone 4° 20' (*second revision*)
 - (Part III)-1982 Half angle of the cone 5° 57' (*second revision*)
 - (Part IV)-1982 Half angle of the cone 9° 15' (*second revision*)
- 5141-1969 Wooden cones for winding yarn
- 5473-1969 Double flanged bobbins used in woollen and worsted mills
- 5492-1969 Pirns for woollen and worsted plain looms
- 6268-1971 Accessories for use in shuttles for plain calico looms
- 7614-1975 Wooden bobbins for ring doubling and twisting frames
- 8684-1978 Classification of terms for shuttles
- 9280-1979 Wooden shuttle blocks for non-automatic looms
- 9287-1979 Wooden shuttle blocks for pirn-changing automatic looms
- 9337 Bobbins and pirns used in textile mills:
 - (Part I)-1979 Wooden flyer bobbins
 - (Part II)-1983 Wooden warp bobbins for rabbeth spindles
- 9794-1981 Boards/blanks for sley bottom, race, cap and box back of cotton looms
- 10310-1982 Nomenclature for formers for yarn packages
- 10795-1984 Accessories for use in shuttles for pirn-changing automatic cotton looms
- 11059-1984 Cylindrical tubes for open-end spinning